



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6405G02331-3G-09

Job Sheet 171451



Part No: RBW6405G02331-3G-09

Job Qty: 4 ea

Part Name: Tail Rotor Conical Ring Puller Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/1/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6405G02331-3G-09 REV:2 IPP REV A 18.01.19 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/8/18	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	4 pcs		2/9/18	0.08	0.50	Large Fab 8		LZ
110	QC	4 pcs		2/9/18	0.00	0.00	QC9		PD 18-3-16
120	QC	4 pcs		2/9/18	0.00	0.00	QC5		PD 19-3-12
122	Outsource	4 pcs		2/9/18	0.00	0.00	Outsource13		AF 18/03/23
124	Packaging	4 pcs		2/9/18	0.00	0.00	Packaging2		AF 18/03/23
126	QC	4 pcs		2/9/18	0.00	0.00	QC6		38
130	Packaging	4 pcs		2/9/18	0.00	0.00	Packaging3-2		9-88 SB
140	QC21-SA	4 Ea		2/9/18	0.00	0.00	QC21		DAS 21 MAR 27 2018

Part Op 100 - WELD

Descriptions: 122 - Issue P/O to Groupe Altech: P/O 003935 Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required

124 - Receive

130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G02331-3G-11	All Thread	4 Ea (1 ea)	90-Start up Operation	
RBW6405G02331-3G-13	Head	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6405G02331-3G-11	4	0	0
	RBW6405G02331-3G-13	4	0	0

Part Specifications

Specifications could not be found.

Doc A: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Q. Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/P ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐			

Date :	Step #:	QTY Effective :
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Description Work Order Deviation	Disposition

Dart Aerospace Ltd.
1270 Abundant Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S052025



Part: RBW6405G02331 - 3G - 09

Job No: 171451

Serial No/Batch: S052025

Revision: 2

Inspector:

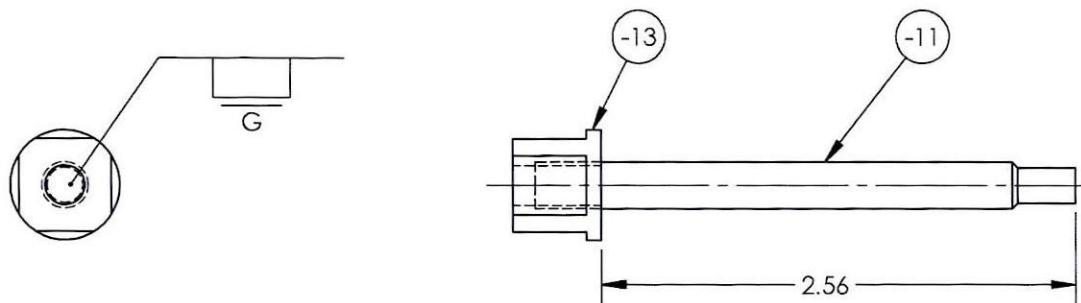
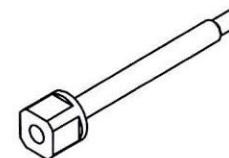
Date: 03/16/18

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Drawing
☐	Finish
☐	Misread
☐	Turning Sequence

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0032	-09 CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC. ASTM B633 TYPE I SC2. CH'D DWG. TOLERANCE WAS .XXX ±.005, .XX ±.01 IS .XXX ±.010, .XX ±.03.	1/26/2017	RJC	SM



(-09)
SCREW WELDMENT

DART AEROSPACE	
TITLE T/R UPPER CONICAL RING PULLER	
DWG NO. RBW6405G02331-3G-09	REV 2
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT ASTM B633 TYPE I SC 2	.XXX ± .010 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .03 ANGLES ± 1°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	AW139
SCALE 1:1	DATE 3/25/2010
SHEET 6 OF 9	

Trancesco delivered.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039353**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039353
PO Date: 3/19/18
Due Date: 3/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171733	RBT18520-5	Weldment -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	3/28/18	2 pcs	0 pcs <i>2x</i>	2 pcs	\$60.00/pcs	\$120.00
2	171451	RBW6405G02331-3G-09	Tail Rotor Conical Ring Puller Pin -Issue P/O to Groupe Altech; P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	3/28/18	4 pcs	0 pcs <i>4x</i>	4 pcs	\$22.50/pcs	\$90.00
Grand Total:										\$210.00

Order Notes

rec'd April 18/23

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Certificat de Conformité / Certificate of Compliance

(007709-1)



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007709 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
20-Mar-2018		Aman		PO039353				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT18520-5 Rev. 171733	RBT18520-5 01 - OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	2	2	0	0	0
2	RBW6405G02331-3G-09 Rev. 171451	RBW6405G02331-3G-09 01 - ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] ASTM B633 TYPE I SC2	ZINC CH	4	4	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.